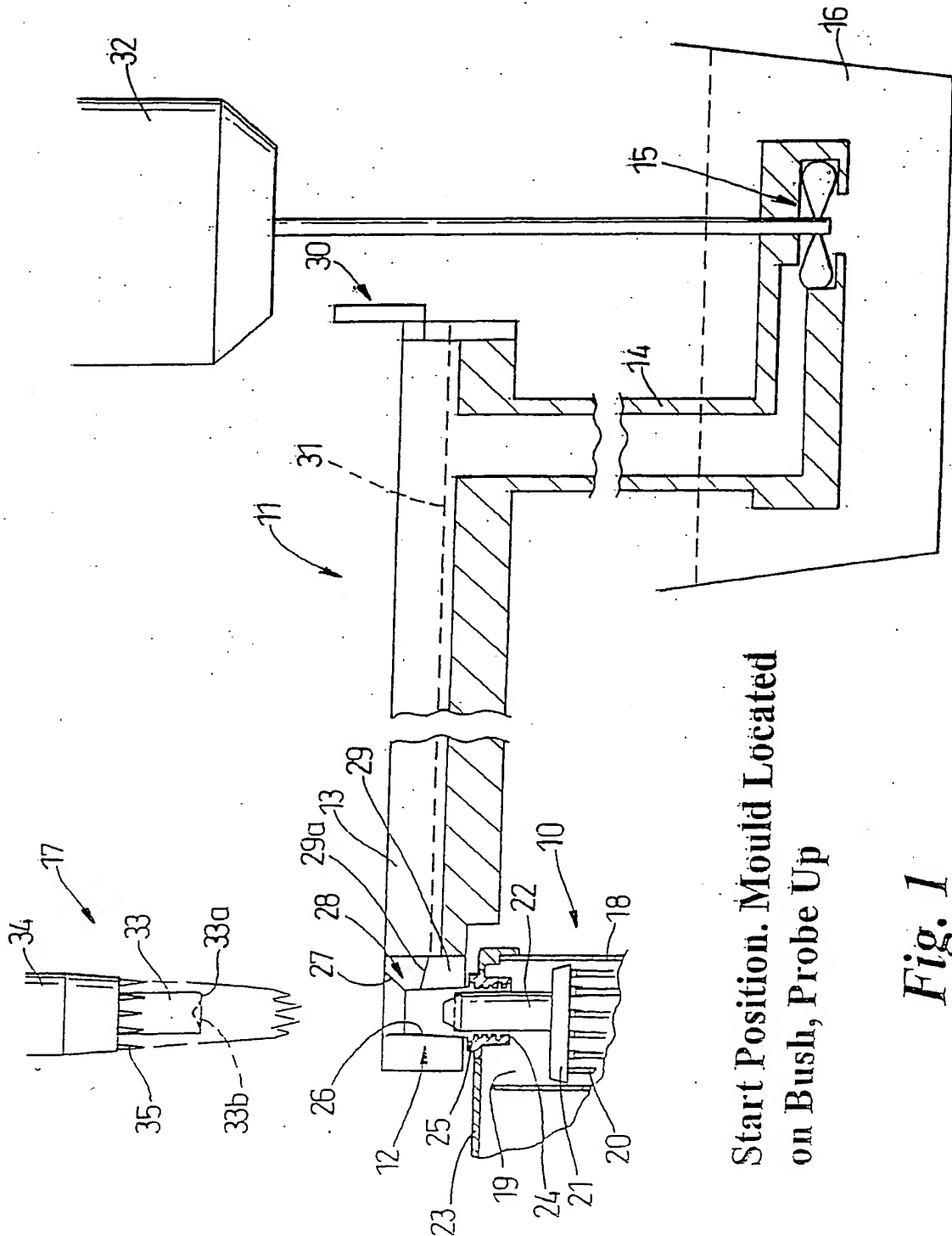


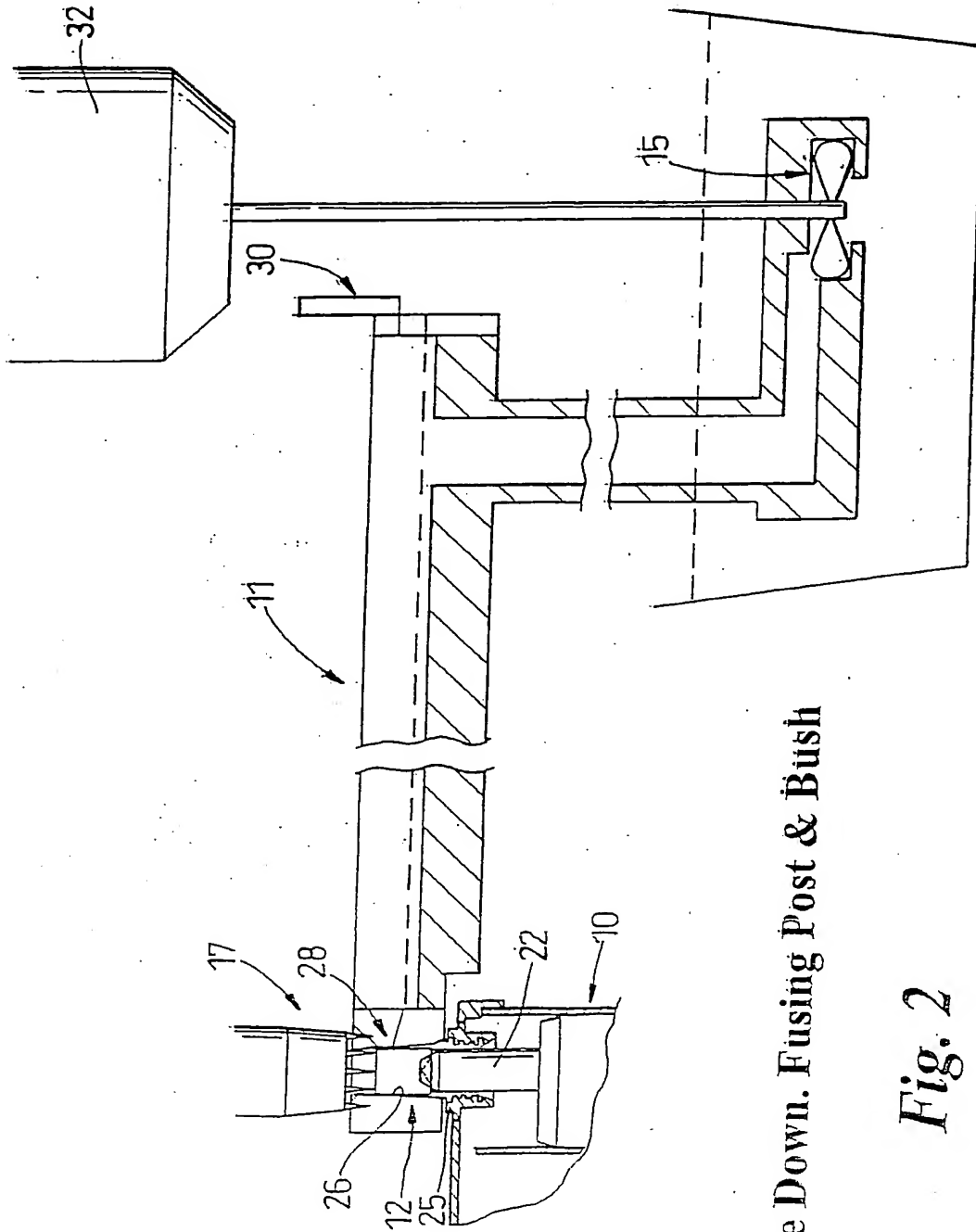
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Start Position. Mold Located  
on Bush, Probe Up

Fig. 1

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Probe Down. Fusing Post & Bush

Fig. 2

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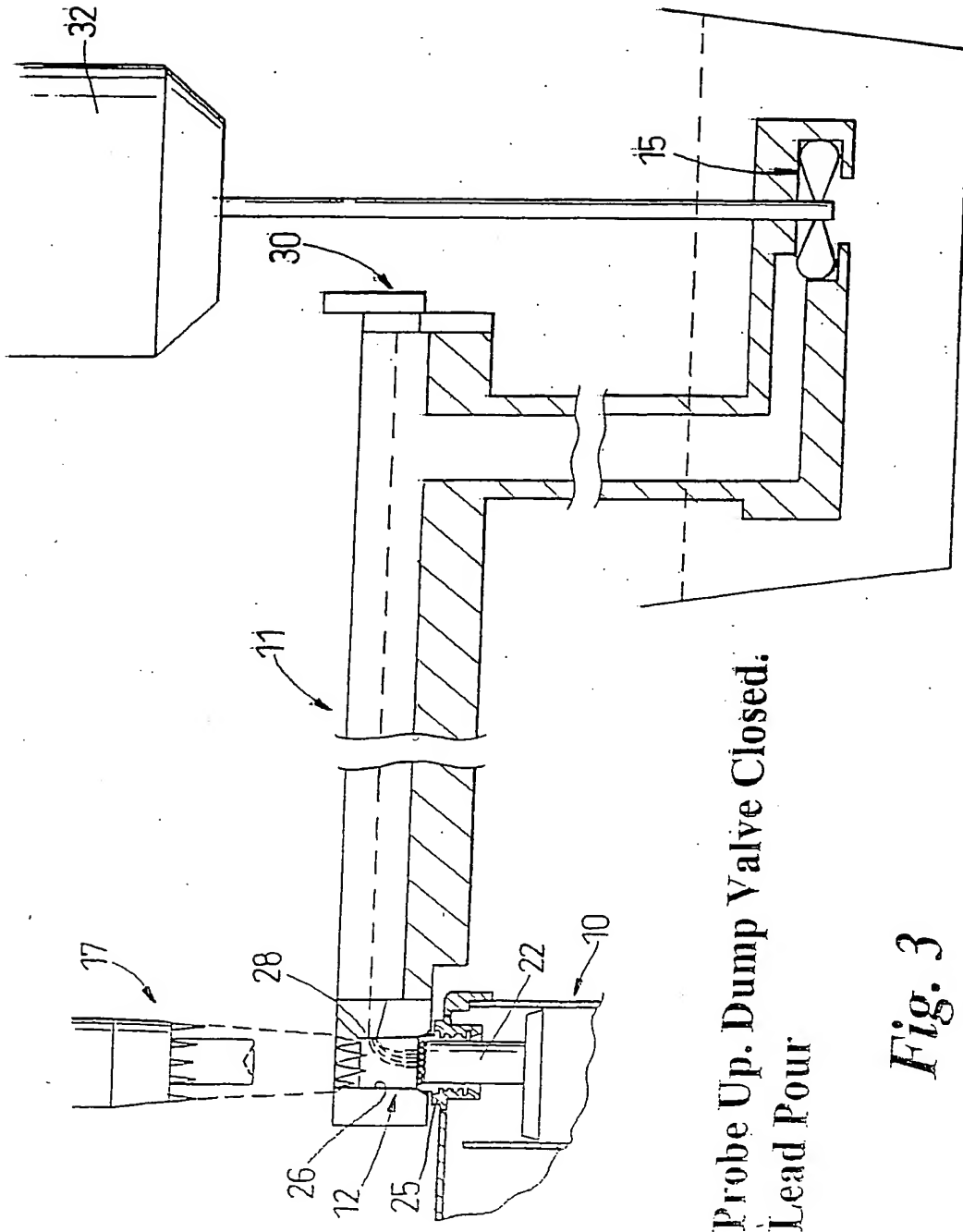
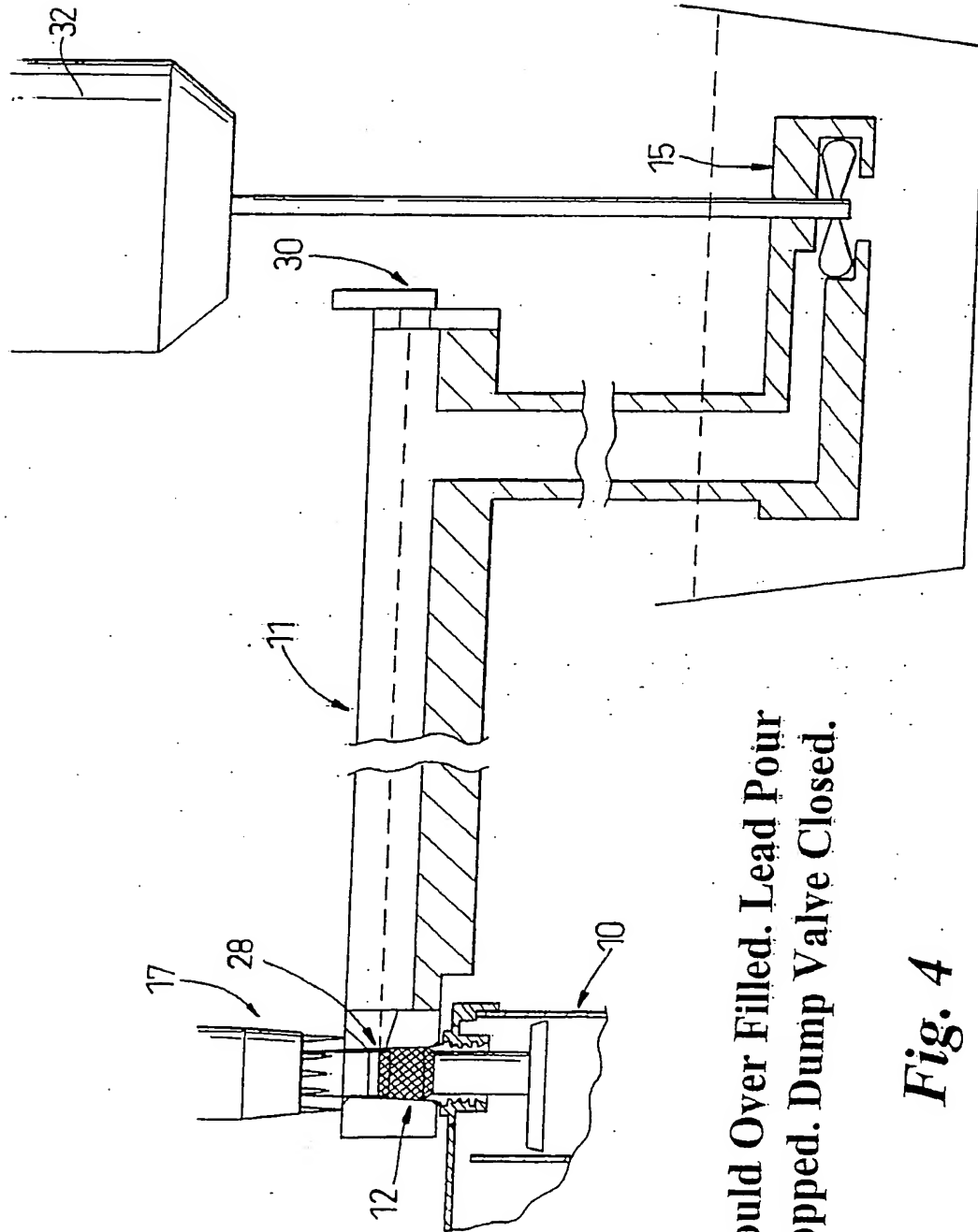


Fig. 3

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Mould Over Filled. Lead Pour  
Stopped. Dump Valve Closed.

*Fig. 4*



**Fig. 5**